
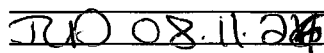


Date: Wednesday, 26/11/2008 12:45:49 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STRUT
<b>Job Number</b> : 43745	
<b>Estimate Number</b> : 10950	
<b>P.O. Number</b> :	<b>Part Number</b> : D2562005
<b>This Issue</b> : 26/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2562 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 35045	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/12/2008 <b>Qty:</b>  <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est A 02.06.07 New Issue NG	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TR0500W035

304 RD Tube .500 x .035W



**Comment:** Qty.: 2.5374 f(s)/Unit Total : 15.2246 f(s)  
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall  
 Batch M110113

SB 09/01/08

(10)

2.0

BRAKE NC

NC BRAKE



**Comment:** NC BRAKE  
 Punch to length as per Dwg D2562

SB 09/01/08

(10)

3.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



**Comment:** SMALL/MED FAB RESOURCE  
 1- Bend end as per Dwg D2562 Angle "D"  
 2- Debur

FF 09-01-08

M-H 09/01/08

(10)

4.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

SB 09/01/09

(410)

5.0

POWDER COATING

POWDER COATING



**Comment:** POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15  
 400 OF  
 10:45

M-H 09/01/09

(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 26/11/2008 12:45:49 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 43745

Part Number: D2562005

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*ell*



Comment: INSPECT POWDER COAT

09-09-01

*X10*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ST264*

*SS 09/01/09 X10*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/01/12*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-01-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

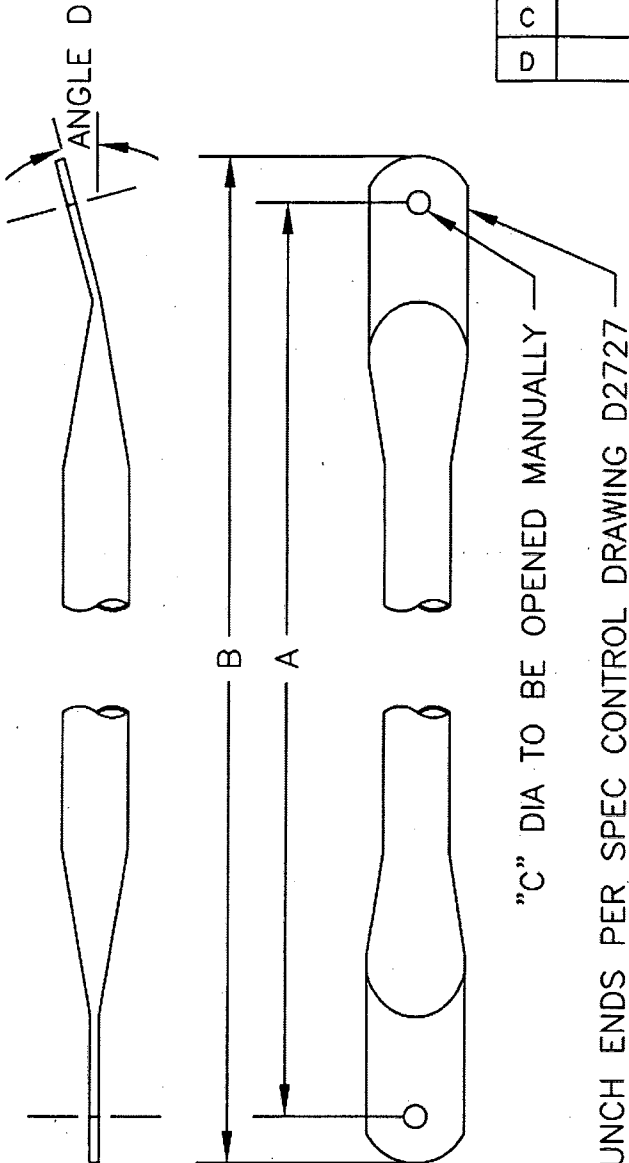
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**


DESIGN CP	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18	TITLE STRUT		SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4345

**RELEASED**05-05-27 **GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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